

Date: Friday, 9/21/2007 12:58:23 PM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : ANGLE |
| Job Number | : 34771 | | |
| Estimate Number | : 12048 | | |
| P.O. Number | : N/A | Part Number | : D20654711 |
| This Issue | : 9/21/2007 | S.O. No. | : N/A |
| Prsht Rev. | : NC | Drawing Number | : D206-547 REV F |
| First Issue | : MA | Project Number | : N/A |
| Previous Run | : 32799 | Drawing Revision | : F |
| | | Material | : N/A |
| Written By | : <u> </u> | Due Date | : 10/5/2007 |
| Checked & Approved By | : <u> </u> | Qty: | 30 |
| Comment | : Est Rev:D 04-11-17 Reformat JLM | Um: | 12 |
| | | Each | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|------------------|--------------------------|
| 1.0 | M6063T5A0750W063 | Angle6063T5X.75X.75X.063 |
|-----|------------------|--------------------------|



Comment: Qty.: 1.0000 f(s)/Unit Total: 12.0000 f(s)
 Material: 6063-T5 (QQ-A-200/9) 0.063" wall
 M6063T5A750W063
 Identify as D206-547-11
 Batch: M 105870

07/11/01 (30)

| | | |
|-----|-------------|-------------------------------|
| 2.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut parts to 12.00" length from 0.063" x 0.75"-angle

2-Deburr

07/11/01 (30)

| | | |
|-----|-----|------------------------------|
| 3.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

| | | |
|-----|-----------------|----------------------------|
| 4.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

07-11-02 (X30)

| | | |
|-----|-----|---|
| 5.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
|-----|-----|---|



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/11/02 (30)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 1D Date: 07/11/05
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 12:58:23 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 34771

Part Number: D20654711

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST220

(30)

07/11/02

N

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

07/11/05

Job Completion



06711105

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|----------------------|-----------------------|---|------------------------|
| DESIGN BW | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED UP | APPROVED KE | DRAWING NO. D206-547 | REV. F SHEET 1 OF 5 |
| DATE 99.02.11 | | TITLE CONSOLE ASSEMBLY | SCALE NTS |
| - | 82.11.23 | NEW ISSUE | |
| A | 83.01.18 | REDRAWN, ADD NOTE 4 | |
| B | 84.10.23 | D206-547 WAS 01.B.81.017 | |
| C | 89.03.30 | REDRAWN | |
| D | 90.12.06 | COMPANY NAME CHANGE MS20470 WAS MS20426 DIM 1.312 WAS 1.0, 13.160 WAS 12.85 | |
| E | 97.10.22 | REDRAWN, ADD -043,-045,-047 | |
| F | 99.02.11 | ADD MS20470AD3-3 RIVET (NC 143) UPDATED WELD DETAIL | |

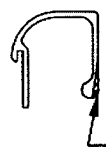
RELEASED
99.03.05 RE

| -041 | -043 | -045 | -047 | PART NUMBER | DESCRIPTION |
|------|------|------|------|--------------|-------------------|
| X | | | | D206-547-041 | CONSOLE ASSEMBLY |
| | X | | | D206-547-043 | CONSOLE ASSEMBLY |
| | | X | | D407-547-045 | CONSOLE ASSEMBLY |
| | | | X | D407-547-047 | CONSOLE ASSEMBLY |
| | | | | | |
| 1 | | | | D2601-1 | CONSOLE SIDE |
| 1 | | | | D2601-2 | CONSOLE SIDE |
| | 1 | | | D2602-1 | CONSOLE SIDE |
| | 1 | | | D2602-2 | CONSOLE SIDE |
| | | 1 | | D2603-1 | CONSOLE SIDE |
| | | 1 | | D2603-2 | CONSOLE SIDE |
| | | | 1 | D2604-1 | CONSOLE SIDE |
| | | | 1 | D2604-2 | CONSOLE SIDE |
| 1 | | 1 | | D2605 | CONSOLE BRACKET |
| | 1 | | 1 | D2606 | CONSOLE BRACKET |
| 1 | 1 | | | D2607 | CONSOLE BRACKET |
| | | 1 | 1 | D2608 | CONSOLE BRACKET |
| 1 | | 1 | | D2709-1 | CONSOLE SIDE RAIL |
| 1 | | 1 | | D2709-2 | CONSOLE SIDE RAIL |
| 1 | | 1 | | D2709-3 | CONSOLE SIDE RAIL |
| 1 | | 1 | | D2709-4 | CONSOLE SIDE RAIL |
| | 1 | | 1 | D2710-1 | CONSOLE SIDE RAIL |
| | 1 | | 1 | D2710-2 | CONSOLE SIDE RAIL |
| | 1 | | 1 | D2710-3 | CONSOLE SIDE RAIL |
| | 1 | | 1 | D2710-4 | CONSOLE SIDE RAIL |
| | | | | | |
| 10 | 8 | 8 | 6 | MS20470AD3-3 | RIVET |
| 18 | 20 | 18 | 20 | MS20470AD3-4 | RIVET |

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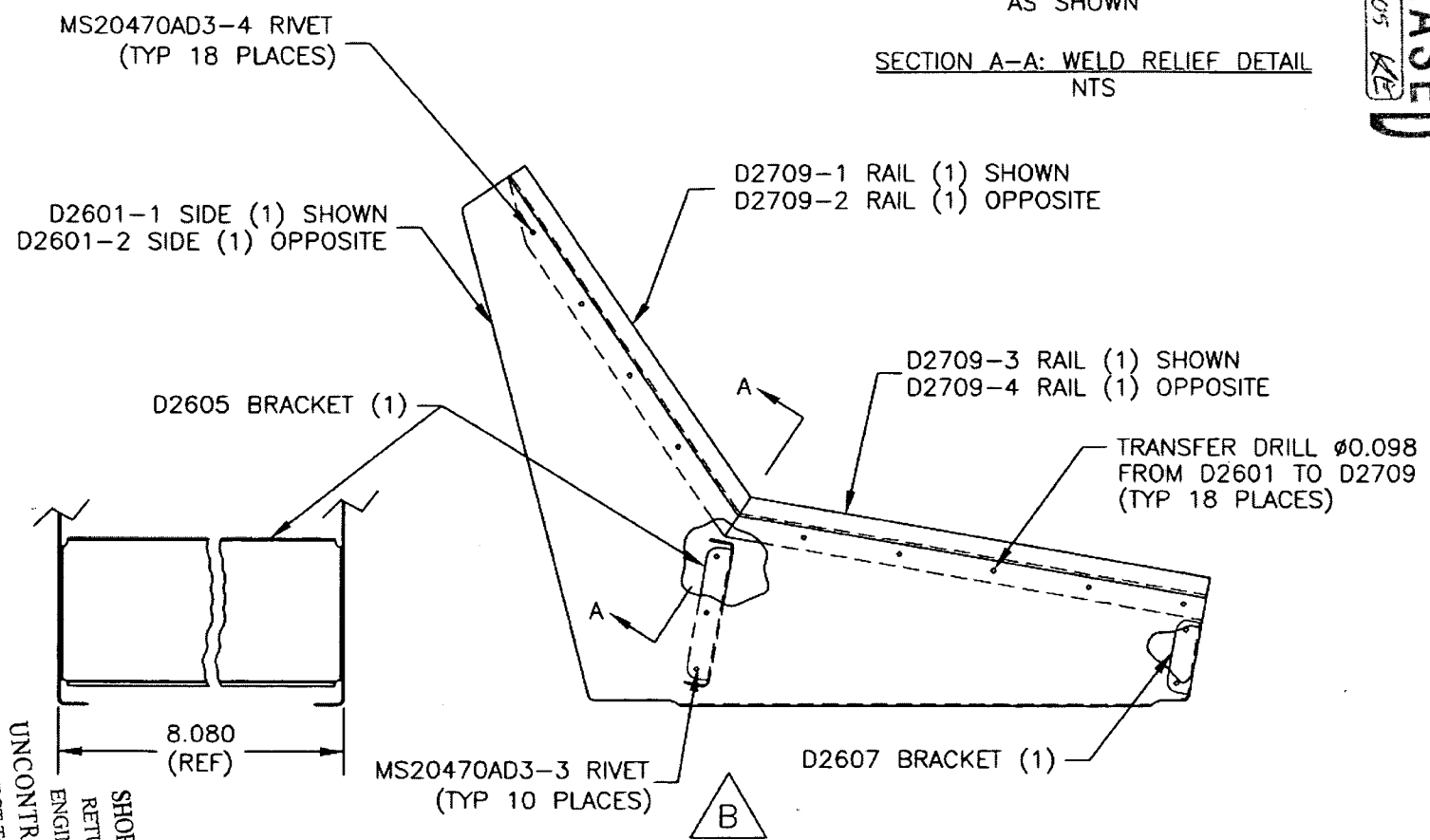
DART

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99.03.05 KE



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D206-547-041 (206 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

| | | | | |
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| DESIGN | BW | DRAWN BY | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
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| DATE | 99.02.11 | DRAWING NO. | D206-547 | REV. F |
| | | TITLE | CONSOLE ASSEMBLY | SHEET 2 OF 5 |
| | | | | SCALE 1:4 |

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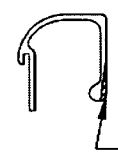
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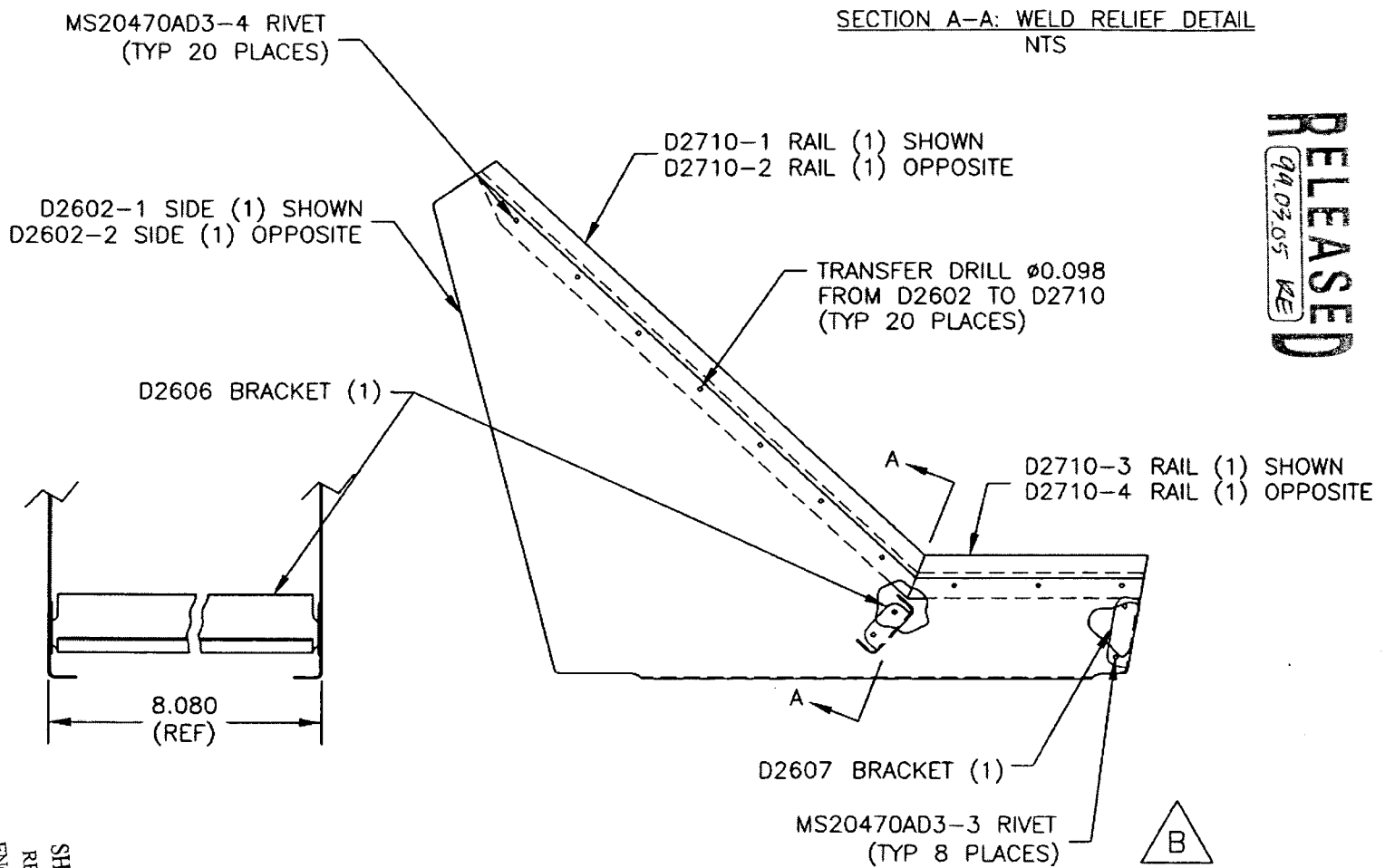
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| DATE | 99.02.11 | DRAWING NO. | D206-547 | REV. F |
| | | TITLE | CONSOLE ASSEMBLY | SHEET 3 OF 5 |
| | | | | SCALE 1:4 |



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



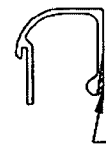
D206-547-043 (206 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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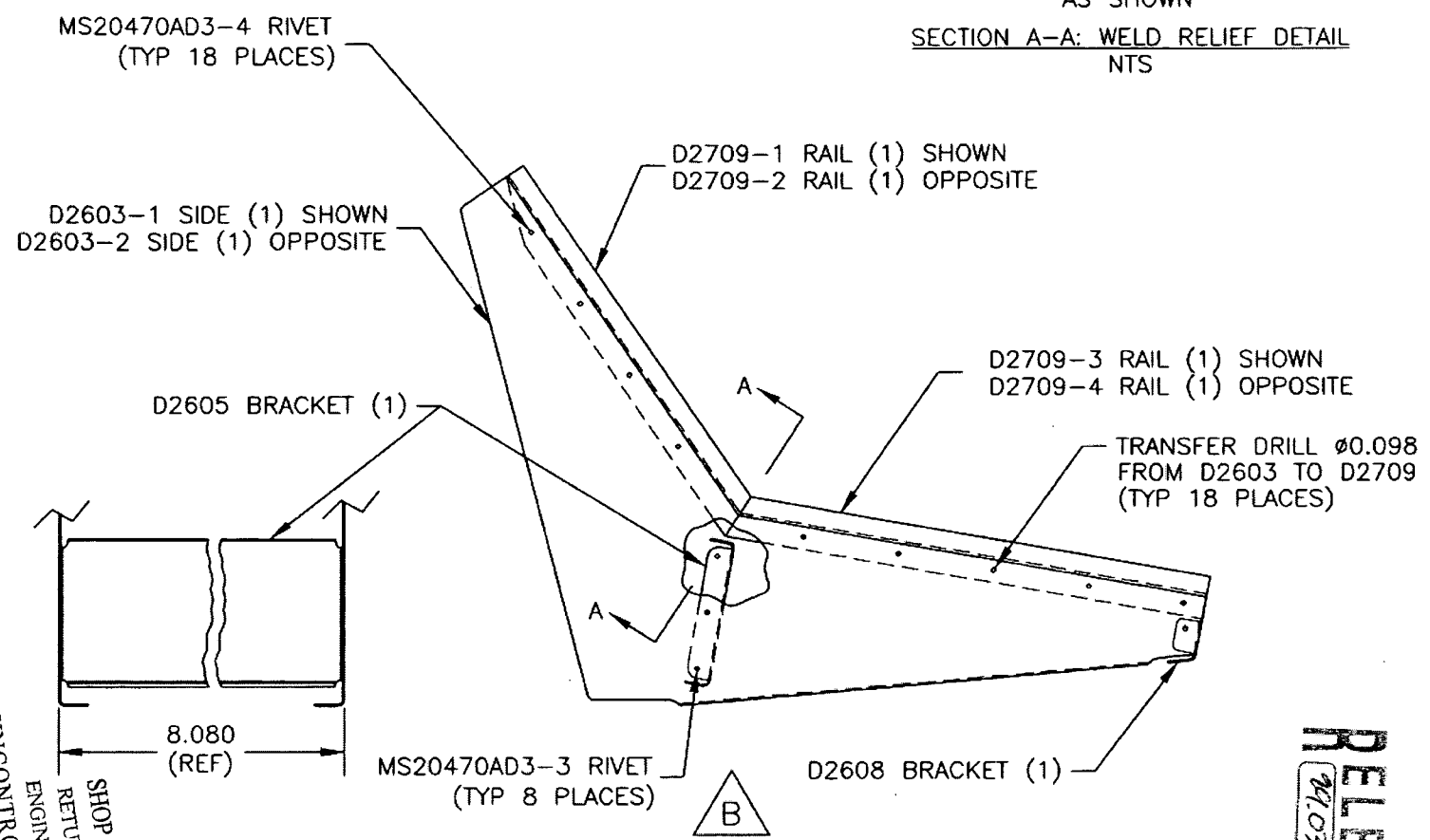
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CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D407-547-045 (407 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
24.03.05 AE

| | | |
|------------------|---------------------------|---|
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| CHECKED JP | APPROVED AE | DRAWING NO. D206-547 |
| DATE 99.02.11 | TITLE CONSOLE ASSEMBLY | REV. F SHEET 4 OF 5 |
| | SCALE 1:4 | |

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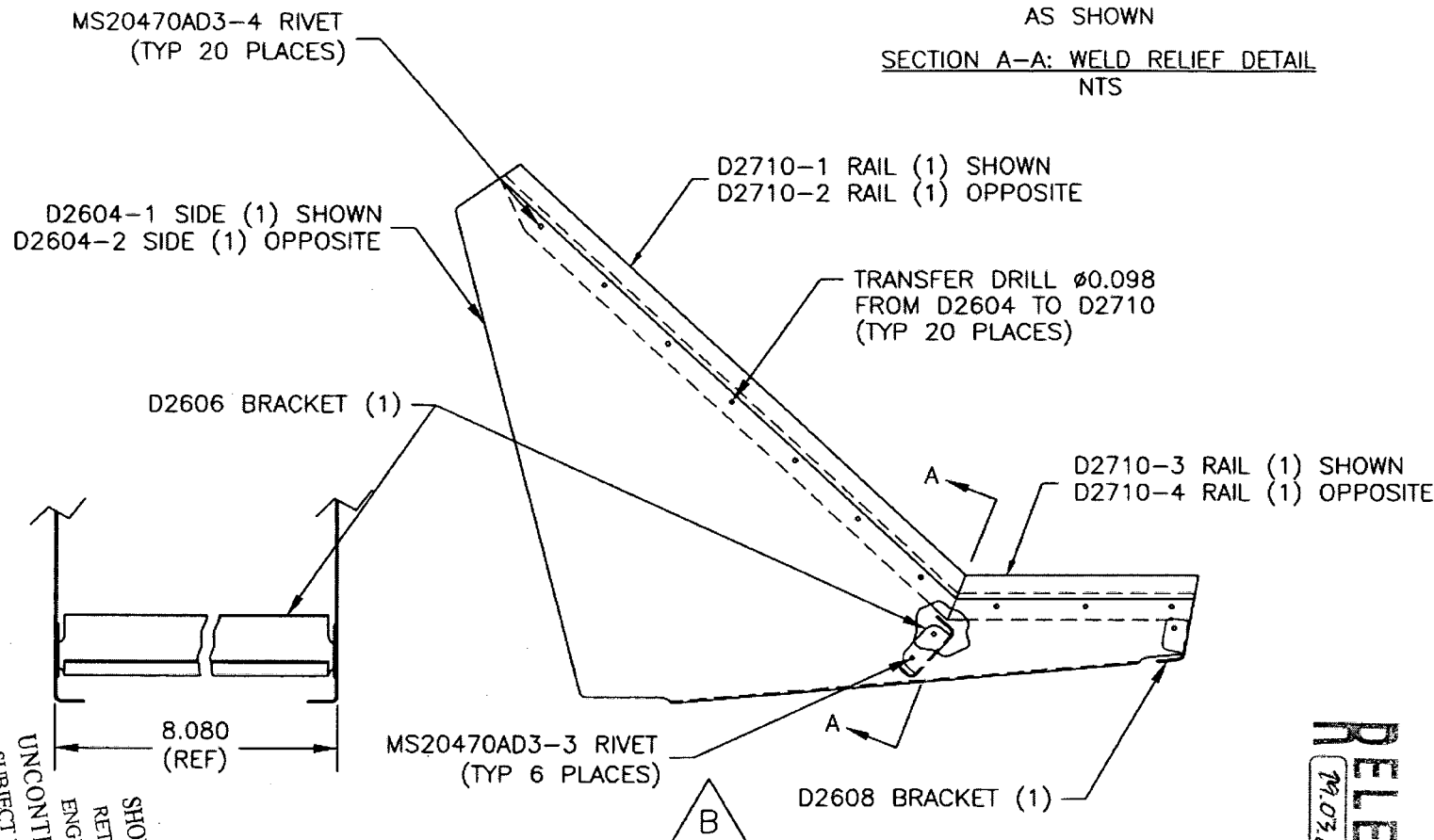
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DART



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



407-547-047 (407 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
17.03.05 KE

| | | | | |
|---------|----------|-------------|------------------|---|
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| CHECKED | KE | APPROVED | KE | |
| DATE | 99.02.11 | DRAWING NO. | D206-547 | REV. F |
| | | TITLE | CONSOLE ASSEMBLY | SHEET 5 OF 5 |
| | | | | SCALE 1:4 |